

Work Order ID 80250

February-15-12 3:32:13 PM

80250

Page 1

Item ID: D3436-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step LH
 Start Date: 15/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3436	Rev A

100 0.00
100 Large Fab (5) 12-9-19
 Large Fab Memo 0.00
 Large Fab Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
 Dwg D3436Dwg Rev: A Qty Part Number Description
 BatchA/RN/A 4130 Welding Rod 1418475 Weld
 left step D3436-7 using welding Jig DT

110 0.00
110 BAND SAW (5) 12-9-19
 Bandsaw Memo 0.00
 Jeaspa Bandsaw 1- Slit part D3436-041 on bandsaw as per Dwg D3436 2-
 deburr

120 0.00
120 QC9- Inspect visual per QSI004- Fusion Welds (DAS 24 12-9-19)
 QC Memo 0.00 5x 12-9-19
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	SmrB 12-9-19			5			
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140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4 START TIME: 9:15 OVEN TEMPERATURE: 400 F FINISH TIME: 9:45	0.00 0.00				5X			mf 12/09/20
--	---	--------------	--	--	--	----	--	--	----------------

145 *145* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 11127500 Memo Wing walk B 11127500	0.00				X 5			all u(01/20
--	--	------	--	--	--	-----	--	--	-------------

W122878

W/O:		WORK ORDER CHANGES					
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Picklist Print

February-15-12 3:32:17 PM

Page 1

Work Order ID: 80250

80250

Parent Item: D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP .A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-1

Manufactured

No

100

Each

33.0000

1

4

D3436-1

Clamp

**

12-9-19

Location

Loc Qty

Loc Code

WA024

33

17679

33

D3436-3

Manufactured

No

100

Each

4.0000

1

4

D3436-3

Left Step

**

12-9-19

86722 *5 X 4

Location

Loc Qty

Loc Code

WA022

4

65157

4

D3436-5

Manufactured

No

100

Each

24.0000

4

16

D3436-5

Bushing

**

12-9-19

87054 x 7

Location

Loc Qty

Loc Code

ST044

20

82071 x 8

46592

20

83316 x 5

WA024

4

75229

4

D3436-9

Manufactured

No

100

Each

4.0000

2

8

D3436-9

Pad

**

5 12-09-20

Location

Loc Qty

Loc Code

GA

83386

4

79670

4

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 15/02/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 29/02/2012 **Req'd Qty:** 4.00 ***A***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170	Identify as per dwg & Stock Location:_____	0.00
-----	--	------

170

Packaging

Packaging

Memo

57486

0.00

180	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

180

QC

Quality Control

Memo

0.00

12/9/24 *JS*

12-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step LH

Start Date: 15/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

5 ϕ BY 12-9-20.

155

0.00

155

Small Fab

Memo

0.00

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

5 ϕ FF 12-09-20

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Smb
12-9-20
17/11/21

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 2

Work Order ID: 80250

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Parent Item: D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3436-7

Manufactured No

160

Each

35.0000

1

4

D3436-7

**

EL 12-9-19

Cap

Location

Loc Qty

Loc Code

WA021

35

56836

35

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	

Stitch-Weld. 3M

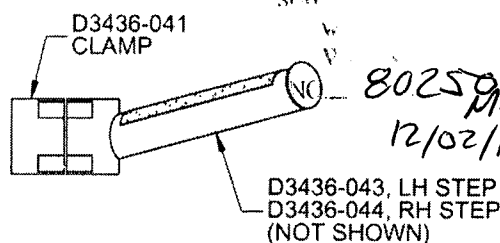
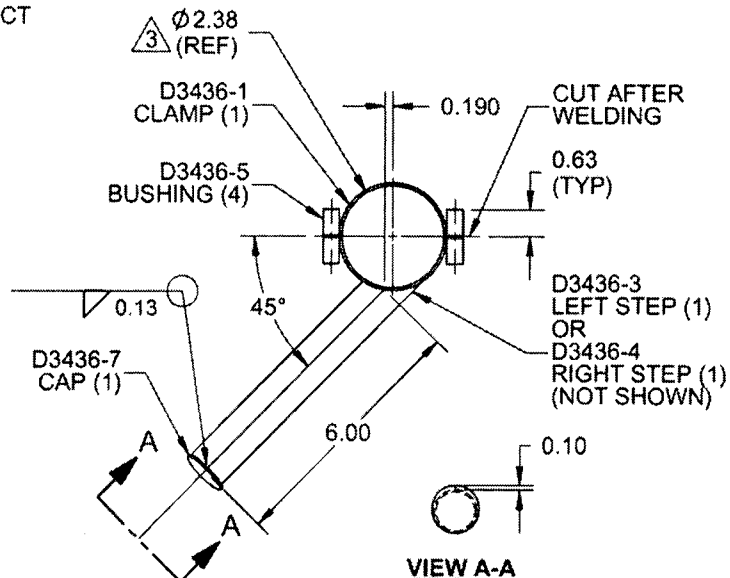
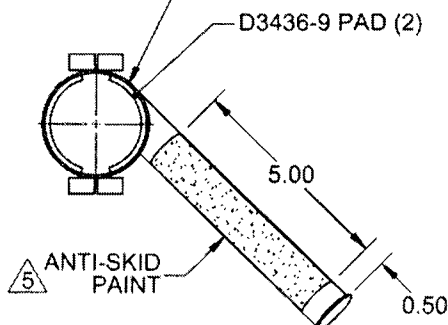
Neoprene High Performance

1300L

DAS

22 12.04.20

BOND WITH CONTACT
CEMENT PER
MANUFACTURER'S
SPECIFICATION
(2 PLACES)



WELDING

RELEASED

05.05.27

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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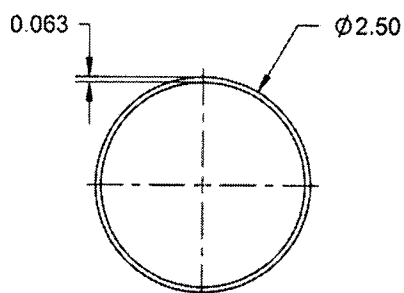
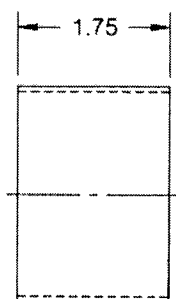
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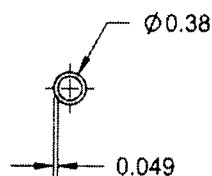
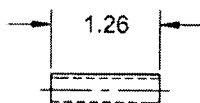


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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80208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

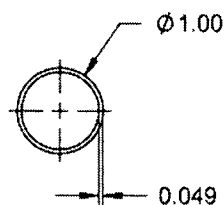
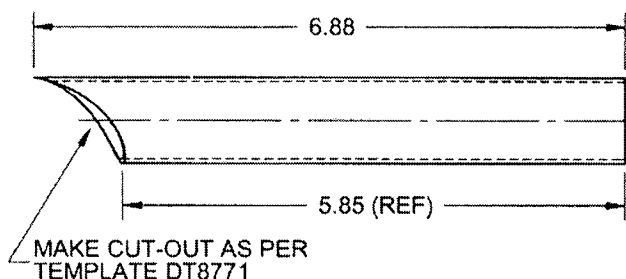
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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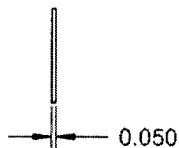
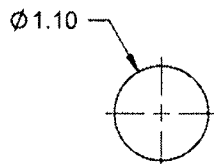
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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90250

W/O:		WORK ORDER CHANGES					
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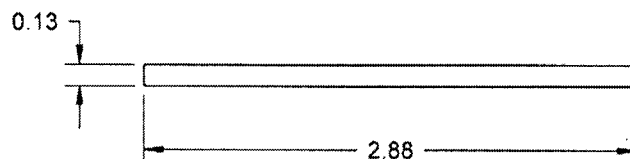
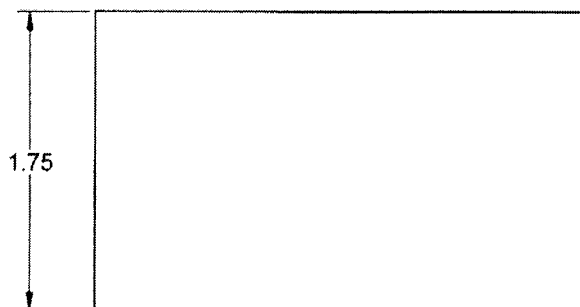
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED
05.05.27 [Signature]

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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902506

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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